Work Order II April-30-13 2:37:29			*100)978*						Page 1
Item ID: D320 Revision ID: Item Name: Filler			Accept	*N900	040	100)* s	etup Sta Sto	1 72	S1* S2*
Start Date: 4/30/ Required Date: 4/30/ Reference:		*6* *6*		Cust Item I Customer:	D:					
	cess Plan:MLゴ				ate:	· · · · · · · · · · · · · · · · · · ·	R	tun Sta Sto	/ ac	R1* R2*
Sequence ID/ Work Center ID	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	······································								
D3208	C			•						0
100			0.00							
100 Waterjet FLOW CNC Waterjet	Memo 1-Cut as p Dwg Rev: Prog Rev: 2-Deburr i	<u> </u>	0.00				15	0		Jm30721
*110 *110* oc	QC2- Inspect parts off Small Fab	machine FAI/FAIB	0.00				15	٥	-	JM13-07-21
Quality Control	Мето		0.00						·	
120	QC8- Inspect parts - se	cond check	0.00				15			
120 QC Quality Control	Memo		0.00 BJ	\mathfrak{D}						· · · · · · · · · · · · · · · · · · ·

NCR: Y	es / No	!			WORK ORDER NON-	CON	NFORM	MANCE / UPI	DATE	•		•
		!								QA Closed:	Date	:
Work Orde	r:			-	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab	1	Water Jet	Engineering Quality
NCR N	o		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Descri	ption of work order update	П	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		•										
quip/Tooling			1 1									
Operator		1]		
Material												
Setup											•	
Other		1										Ì
Process	_	1				İ						
Supplier	-	<u> </u>										
Training	_											
Unapproved		<u>l</u>	1		<u></u>	1	T CATE	CORY		<u> </u>		<u> L</u>
1			 		General	AUL	T CATE	GURY			······································	
Landin	g Gear Bending				Bend		Grain			Ovalized	Г	Pressure/Forced
ŀ	Centre N	ot Conco	ntric to C	\s\-	BOM/Route	\vdash	Hardwa	ro	-	Over/Under	taloranco	Temperature/Cure
}	Cracks	ot conce	meric to C	″³ -	Broken/Damaged			on Incomplete	-	Part Incorre	<u> </u>	Weld
ŀ	Crushed/	Crimned		-	Burrs	_	ł .	ions Incomplete/	Unclear	Part Lost/Mi		Wrong Stock Pulled
1	Cuffs	Cimpeu		-	Contamination	\vdash	Mainte	,	-	Part Moved		
	Heat Trea	at			Countersink	-	Mislabe			Positioned V	Vrong	
ŀ	Inspectio		Tube	—	Cut Too Short	-	Misread		-	Power Loss/		Other
	Ripples in	•			Drill Holes		Offset	-	<u> </u>	1		1
ŀ	Torque V		Extrusion		Drawing	-	4	Calibration				·
Ì	Turning S			<u> </u>	Finish		4	Sequence				· · · · · · · · · · · · · · · · · · ·
	Wave/Tv	-			Folio		4	Dimensions				7,171

DQA: Date:

100978

Page 2

Revision ID:	D3208-7			Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1* S2*	:
Start Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:							
Approvals:		ń:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	171	R1* R2*	
Sequence ID/ Work Center II 130 *1 20* HandFinish Hand Finishing)	Operation Description Chemical Conversion Co	oat per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp	
140 *140* QC Quality Control		QC7-Inspect Chemical C	Conversion Coat	0.00				15				0AS 95	3·61·2
150 *150* Packaging Packaging		Identify as per dwg & Sto	ppP <u>101000</u>					_15 x	<u> </u>		_¶.,	W 13-	07-20

NCR:	Yes	1	No	
INCIL.	163	,	INO	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
	Date: 2 51-08-11 adv	

	QA Closed:	740	C.L	2	
ÞΕ	PARTMENT/P	ROCESS			
		Water Jet		Engineering	
	Prod.	Eng. Coor.		Quality	
	Rec/Store	/Packaging		Other	

Work Orde	er:	1				DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part 1	-	:				Rework Scrap Use-as-is Work Order Update	Machining Small Thermoforming Finis			Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		7			Descri	ption of work order update	l:	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator	Ш												
Material		ļ									:		
Setup	Ш	·											
Other	Ш												
Process	Ш	·											
Supplier	Ц												
Training	Ш												
Unapproved													
	÷						AUL'	T CATE	GORY				
Landi	$\overline{}$				_	General					,	-	_
	$\boldsymbol{\vdash}$	Bending			_	Bend	Ш	Grain			Ovalized	L	Pressure/Forced
	\vdash	Centre No	t Concer	itric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	-	Cracks				Broken/Damaged	-		ion Incomplete		Part Incorre	⊢	Weld
	$\boldsymbol{\vdash}$	Crushed/0	Crimped		<u> </u>	Burrs	-		ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	\vdash	Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved		
		Heat Trea				Countersink		Mislabe			Positioned V	_	_
	\vdash	Inspection		Tube		Cut Too Short	ш	Misread	i	L	Power Loss/	Surge	Other
	Ш	Ripples in			L	Drill Holes	\vdash	Offset					
	Ш	Torque W		xtrusio	ո _	Drawing	-		Calibration				· · · · · · · · · · · · · · · · · · ·
	$\boldsymbol{\vdash}$	Turning Se	-			Finish	Ш	Out of S	Sequence				
		Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				

Work Orde					Page 3							
Item ID: Revision ID: Item Name:	D3208-	7		Accept	*N900	04 0	100)* s	Setup Star	*N	S1* S2*	
Start Date: Required Date: Reference:	4/30/13 : 4/30/13	- · · · · · · · · · · · · · · · · · · ·	*6* *6*		Cust Item I Customer:	D:						
Approvals:	Proces	s Plan:	Date:	Tooling:	D:	ate:		F	Run Stai	"I/J	R1*	
•	QC:_		Date:		D	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160		QC21- Final Inspection	- Work Order Release	0.00								
160 QC Quality Control		Memo		0.00				—_ <i>M</i>	C5 1	3-07-7 MLD	3-13-0	- 57-2

	i											i v 🙀
	l i									DQA:	Date	·
NCR: Y	es / No				WORK ORDER NON-	COI	VFOR	MANCE / UPDATE				
	:									QA Closed:	Date	
Work Orde	r:				DISPOSITION			AGAI	INST DE	PARTMENT	/PROCESS	
WOIR OIGE					Rework	۱ ٦		Skid-tube Crossi	tube	1	Water Jet	Engineering
Part N	o. '				Scrap	1		Machining Small		Pro	d. Eng. Coor.	Quality
	:				Use-as-is]	Thern	noforming Finis	hing	4	re/Packaging	Other
NCR N	0				Work Order Update]		Large Fab Compo	osite]	Supplier	J ∐
Root		<u> </u>		Descri	ption of work order update	T	Initial	Action		Sign &		
Cause	Date.	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	_											
Equip/Tooling	-											
Operator	_											
Material			Ì									
Setup Other		1										
Process	┤					1						
Supplier												
Training												
Unapproved	:											
					F	FAUL	LT CATE	GORY				
Landir	g Gear				General		7		_	,	_	_
	Bending				Bend	_	Grain		-	Ovalized	<u> </u>	Pressure/Forced
-	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	—	Temperature/Cure
	Cracks	(Cutimer = 1			Broken/Damaged	-		ion Incomplete		Part Incorred] -	Weld
	Crushed/ Cuffs	crimped		<u> </u>	Burrs	-	Mainte	cions Incomplete/Unclear	<u> </u>	Part Lost/Mi Part Moved	issing	Wrong Stock Pulled
ł	Heat Tre	at		-	Contamination Countersink	\vdash	Mislabe		\vdash	Positioned V	Vrong	
ŀ	Inspection		n Tuhe	<u> </u>	Cut Too Short	\vdash	Misrea		-	Power Loss/		Other
	Ripples in	•		-	Drill Holes	-	Offset	-	L	1. 0.1.0, 2033/		19.000
Ì	Torque V		Extrusio	n	Drawing		4	Calibration				
	Turning S				Finish		4	Sequence				
	Wave/Tv	vist in Tu	be		Folio		Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-30-13 2:37:28 PM

Work Order ID:

100978

Parent Item:

D3208-7

Parent Item Name:

Filler

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 6.00

Required Qty: 6.00

IPP: B04.05.25Material changed for Step 4KJ/JLM IPP REV C:PER REV E JLM VERIFIED BY:EC IPP REV:D 12.04.20 as per dwg rev.C DD verf:EC Comments: IPP REV C:PER REV B 12-03-23

Ş.,		JENT VERNITED D	1.00 111 1	(D 1.D 12	2.0 1.20 us per	anglene be								
	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
× .	M6061T6S.080 6061-T6 .080 Sheet		Purchased	No	· · · · - · - · · - ·			sf	180.5973		0.5696844			Jn13-07
					Location		Loc Qty	Lo	c Code					

180.597264 117285 0.497264 124786 180.1

126309

MAT021

126309

												DQA:	Date	<u>)</u> : _	
NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORM	/IANCE / UP	DATE				
-						_						QA Closed:	Date	<u>::</u>	
Nork Orde	r:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	-	: i				-	Rework	1		Skid-tube	Crosstube	7	Water Jet	٦	Engineering
Part N	lo.	:					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	7	Quality
	_				-	Į	Use-as-is	1		noforming	Finishing	Rec/Stor	re/Packaging	٦	Other
NCR N	lo.	1				١	Work Order Update	1 1		Large Fab	Composite	1	Supplier	٦	
								•							_
Root					Desc	_	ntion of work order update	I	nitial	Ac	ction	Sign &			
Cause	_	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	_	QC Inspector
oc/Data	_													ĺ	
quip/Tooling	4														
perator	_													-	
laterial	_								-						
etup	_	;					•							İ	
ther	4													1	
rocess	_														
upplier	\dashv							1						-	
raining	\dashv													1	
napproved		:							TCATE	CORY			<u> </u>		
		`~~					····	AUL	T CATE	JURT					
Landi		Bending			Γ	\neg	General Bend		Grain			Ovalized	Г	7	Pressure/Forced
	-	Centre No	nt Conce	ntric to (7/s	_	BOM/Route	-	Hardwa	ro	-	Over/Under	tolerance	_	Temperature/Cure
	-	Cracks	or conce	inchic to t	,,, ,	\dashv	Broken/Damaged	\vdash	1	on Incomplete	-	Part Incorred	 	_	Weld
		Crushed/	Crimned		ŀ	_	Burrs		1	ions Incomplete/	/Unclear	Part Lost/Mi	}		Wrong Stock Pulled
٠	_	Cuffs	cimped		ŀ		Contamination	\vdash	Mainte		-	Part Moved			Work Stock Fulled
	-	Heat Trea	it		}		Countersink		Mislabe			Positioned V	Vrong		
	\vdash	Inspection		Tube	ŀ	-	Cut Too Short	-	Misread		_	Power Loss/	_	٦,	Other
	_	Ripples in			Ì	_	Drill Holes		Offset		L		ĭ L		
		Torque W		Extrusion	,		Drawing		4	Calibration					
		Turning S			Ī		Finish		Out of s	Seguence				_	. "//

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	100978
Description: Filler	Part Number:	D3208-7
Inspection Dwg: D3208 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.001	0.100			: V	Jhmoi
2.90	+/-0.030	2903	-		V	
3.95	+/-0.030	3.956"	_		V	
0.13	+/-0.030	0.137"	_		V	
0.080	+/-0.010	0.079"	_		٧	
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ANA					,	
		-			1	
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					·	
			QAn			

Measured by:	Jn	Audited by:	27	Preliminary Approval:	-
Date:	13-07-21	Date:	13720	Date:	

Rev	Date	Change	Revise	diby	Approved
<u>A</u>	12.05.22	New Issue	KJ	фX	1 1/1
				-1/-1	142

